

Split.

Work Order ID 57234 - 1

March 30, 2010 6:16:48 PM

Page 1

Item ID: D4082-1

Revision ID:

Item Name: Mounting Bracket

Start Date: 30/03/2010 Start Qty: 4.00

Required Date: 31/03/2010 Req'd Qty: 4.00

Reference:

Good
2
Apr 10-03-30

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4082

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut Blank as per file D4082-1_BLANK

0.00

DO NOT PASS IN DEBURRING MACHINE

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA919

FOLIO REV: AA

DWG REV: A

0.00

DEBURR

Handwritten signature

x2

Handwritten circled 'P'

Handwritten circled '1'

10-04-01

B 10-3-30

Work Order ID 57234

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Page 2

Item ID: D4082-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 30/03/2010 Start Qty: 4.00



Required Date: 31/03/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

JL

10-04-01

(2)

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jm 10-04-01

(2)

Quality Control

131

Drill AS per Dwg
using DT8560

Memo

0.00

0.00



Small Fab

Small Fab

Jm 10-04-01

(2)

Work Order ID 57234

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Page 3

Item ID: D4082-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 30/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

132

QC5- Inspect part completeness to step on W/O

0.00

8/10/04/01

(+2)

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

m.f 10/04/01

(2x)

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

m.f 10/04/01

(2x)

Powdercoat

Memo

0.00

Powder Coating

M113170

Over Temp : 320 °C
Start Time : 2:10
Finish Time : 2:40

Work Order ID 57234

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Page 4

Item ID: D4082-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 30/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-4-15 (24)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-4-1 (24) SL

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/07
MF 10-4-6

Picklist Print

March 30, 2010 2:08:22 PM

Page 1

Work Order ID: 57234

Parent Item: D4082-1

Parent Item Name: Mounting Bracket

Comments: IPP REV:A NEW ISSUE 10-03-30 JLM VERIFIED BY:EC

Start Date: 30/03/2010

Required Date: 31/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X12.00 0		Purchased	No			100	f	6.6206	9.1225			

6061-T6 Bar 1.00 x 12.00

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT05

6.6206

104719

2.5

106701

4.1206

B33680

33680 X 2

B10-3-30

15.00
10.03-30
This Batch
Only

818

DART AEROSPACE LTD		Work Order: 57234
Description: mounting bracket		Part Number: 4082-1
Inspection Dwg: 4082	Rev: A	Page 1 of 2

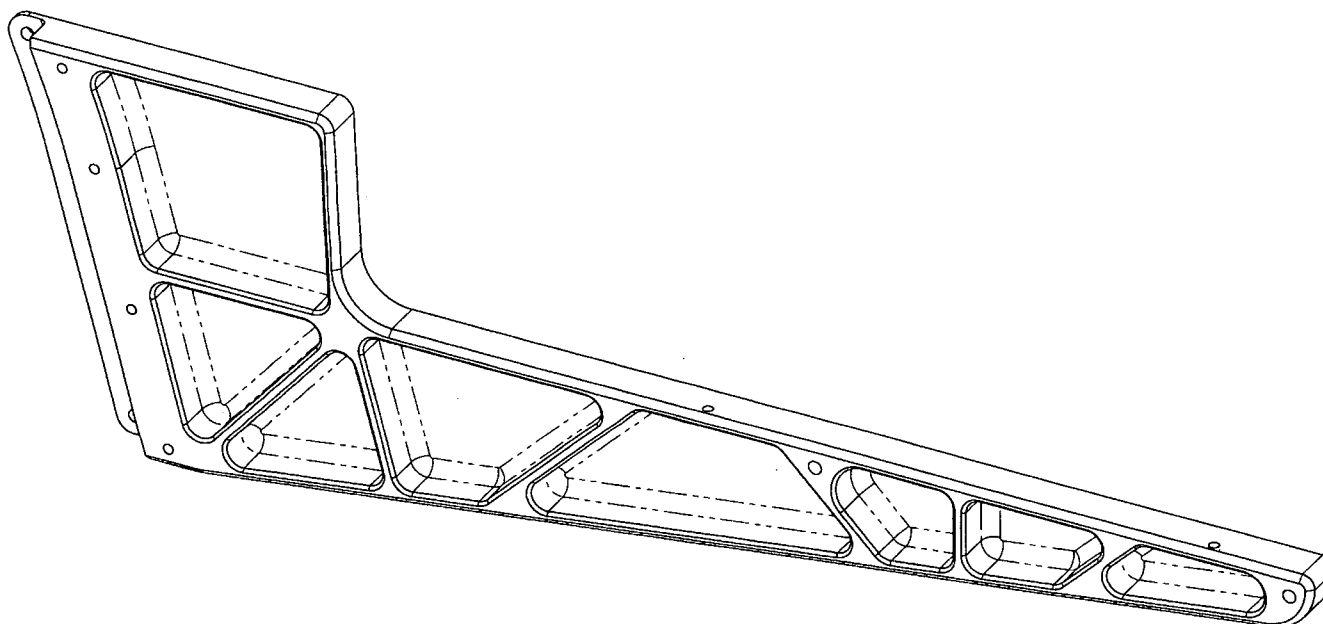
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26-13	+ .030					
Ø.257	+ .006 - .001	.258	✓			
1.38	+ .030	.38	✓			
1.076	+ .010	1.076	✓			
6.72	+ .030	6.730	✓			
1.985	+ .010	1.985	✓			
.440	+ .010	.440	✓			
5.25	+ .030	.250	✓			
4.00	+ .030					
9.372	+ .010	9.372	✓			
13.848	+ .010					
Ø.191	+ .005 - .001	.191	✓			
1.035	+ .010	1.035	✓			
.500	+ .010	.501	✓			
2.776	+ .010	2.776	✓			
8.00	+ .030	8.001	✓			
7.546	+ .010	7.546	✓			
1.000	+ .010	1.001	✓			
3.290	+ .030	3.285	✓			
3.11	+ .030	3.108	✓			
.250	+ .010	.253	✓			
4.720	+ .010	4.716	✓			
6.37	+ .030	6.370	✓			

Measured by: JL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10.04.01	Date: 10.04.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4082-1 MOUNTING BRACKET

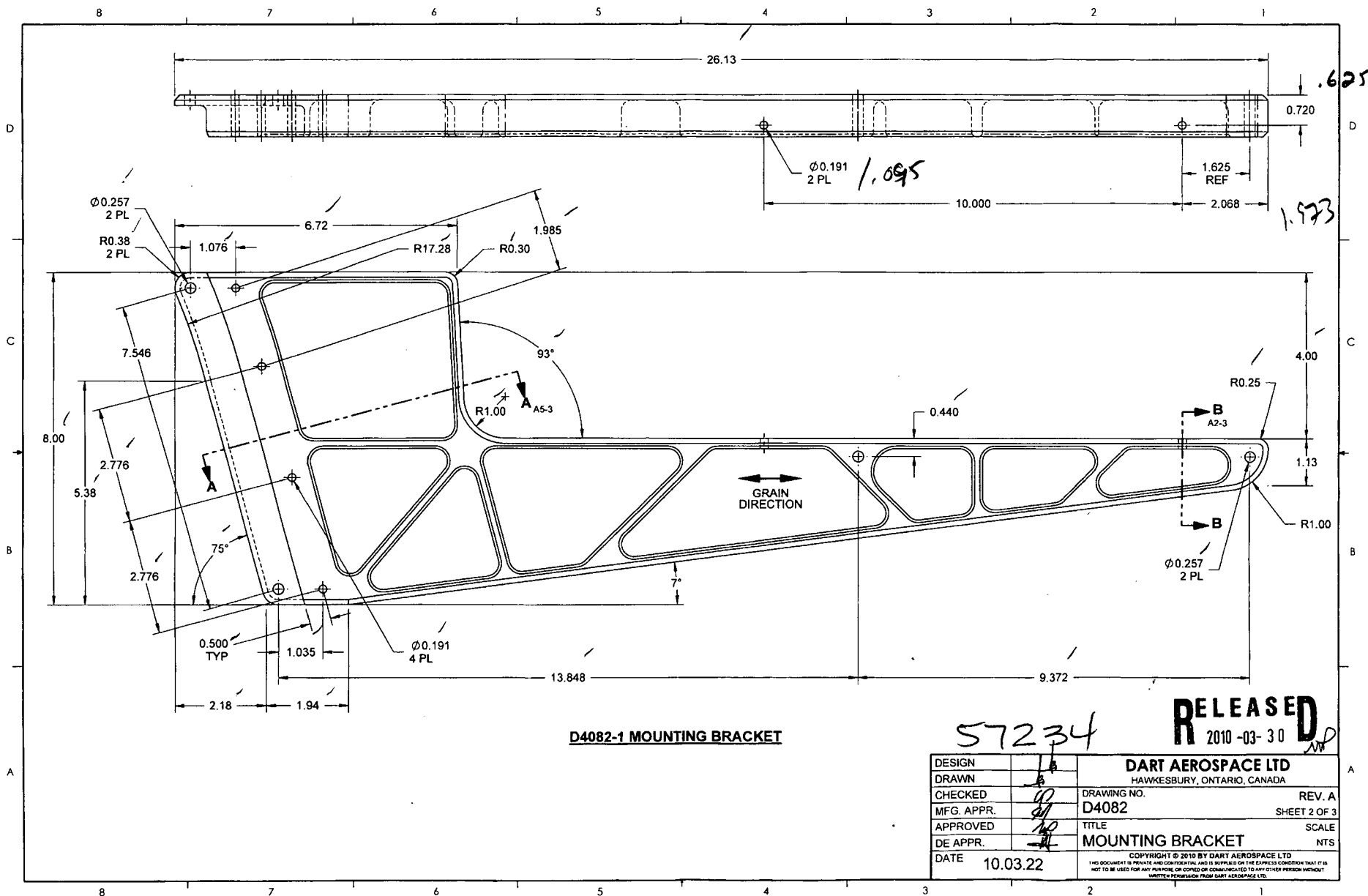
RELEASED
2010-03-30
WJP

57234

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET (OR PLATE)
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR
AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4082-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.61 lbs

A	NEW ISSUE	MB	10.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4082	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING BRACKET	NTS
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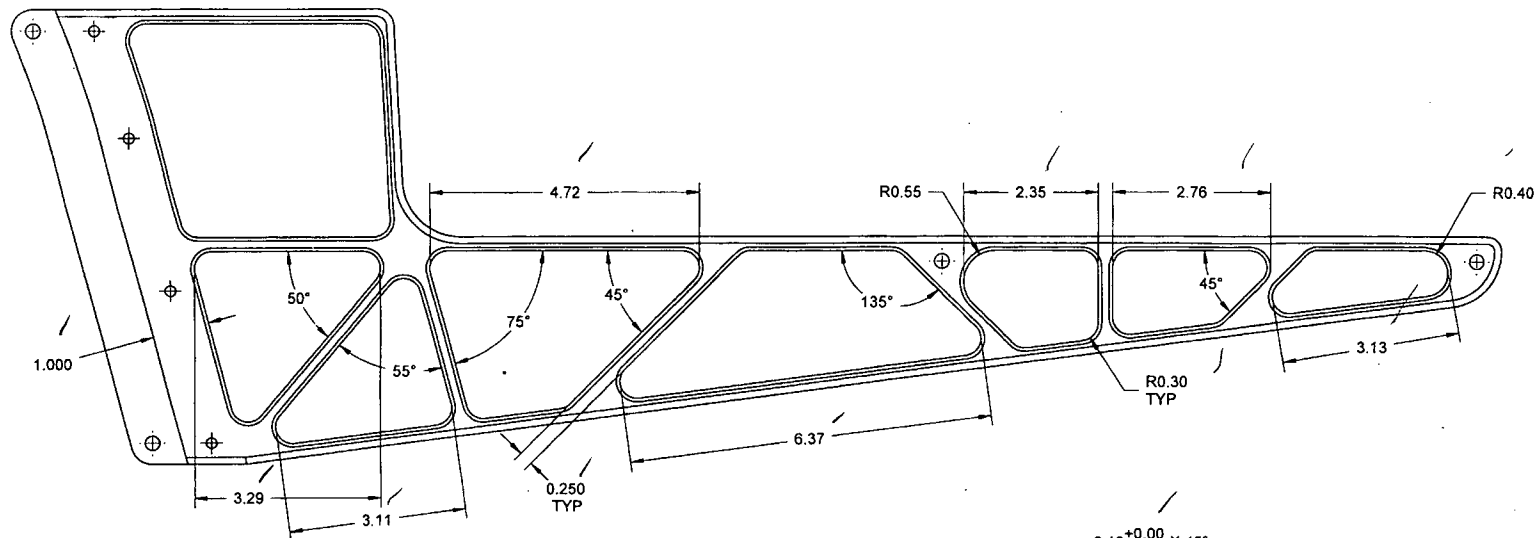
D4082-1 MOUNTING BRACKET

57234

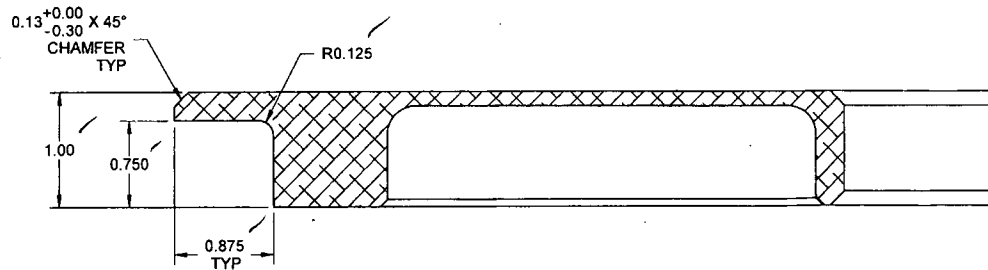
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4082 TITLE MOUNTING BRACKET SCALE NTS
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		REV. A
DATE	10.03.22	SHEET 2 OF 3

RELEASED 2010-03-30

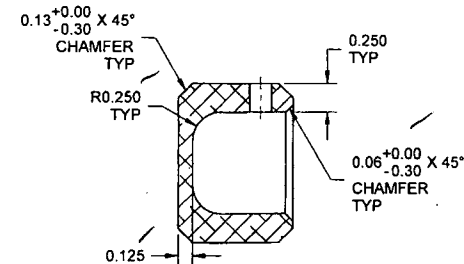
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D4082-1 MOUNTING BRACKET
SUPPLEMENTAL VIEW



SECTION A-A C5-2
SCALE 2X



SECTION B-B C1-2
SCALE 2X

RELEASED
2010-03-30

DESIGN	1A	DART AEROSPACE LTD	
DRAWN	1A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. A
MFG. APPR.	90	D4082	SHEET 3 OF 3
APPROVED	90	TITLE	SCALE
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